

**IN THE SPECIFICATION**

*Please add the following before the first paragraph beginning on page 1, line 1 to read:*

**BACKGROUND****FIELD**

*Please add the following before the second paragraph beginning on page 1, line 3 to read:*

**DESCRIPTION OF THE RELATED ART**

*Please amend the paragraph that begins on page 2, line 11 to read:*

For example, in reference to FIG. 1 of the drawings, if the gravity casting of a cylinder block in a V-shape is performed, with the crankshaft bearings PV in the upper portion, the situation is especially favorable for dimensional control of the ~~drumsbarrels~~, in particular when ~~sleeves-liners~~ inserted during casting are to be overmolded.

*Please amend the paragraph that begins on page 2, line 17 to read:*

Indeed, the base of the mold makes enables all of the devices for guiding the metal pins, which form the ~~drumsbarrels~~, to be placed in direct contact with the solidified alloy, or the metal pins that serve as a support for the ~~sleeves-liners~~ CH to be placed on these ~~drum-barrel~~ pins and themselves overmolded by the liquid alloy.

*Please amend the paragraph that begins on page 3, line 10 to read:*

Indeed, in reference to FIG. 2, where a schematic cross-section of the mold is shown, it is necessary to provide a metal pin system to ensure that the stripping can occur in two directions D and D' shown in FIG. 2, or a ~~sleeveliner~~-holder pin system, which the necessary integration with a risering system would be extremely difficult to carry out.

*Please amend the paragraph that begins on page 3, line 19 to read:*

### SUMMARY

The aim of the present invention is to overcome these limitations of the known prior art, and to propose a improved casting method that makes it possible to achieve the objectives of optimizing the mechanical characteristics, in particular in terms of fatigue, in areas such as the crankshaft bearings of a cylinder block, as well as the objectives of dimensional control of the corresponding ~~drums~~barrels, in particular when said bearings comprise ~~sleeves~~liners inserted during casting.

*Please amend the paragraph that begins on page 4, line 3 to read:*

- forming a core having at least one ~~drum~~barrel intended to form a cylinder in the part and at least one cavity intended to form, in the part, a bearing and/or retaining zone for a working component such as a crankshaft, and at least one cooling unit in close proximity to the cavity,

*Please amend the paragraph that begins on page 5, line 12 to read:*

- a core having at least one ~~drum~~barrel intended to form a cylinder in the part and at least one cavity intended to form, in the part, a bearing and/or retaining zone for a working component such as a crankshaft, and at least one cooling unit in close proximity to the cavity,

*Please add the following before the paragraph that begins on page 6, line 17 to read:*

### BRIEF DESCRIPTION OF THE DRAWINGS

*Please amend the paragraph that begins on page 7, line 3 to read:*

### DETAILED DESCRIPTION

First, FIG. 3a shows a central bundle of cores intended to participate in the casting of a V-shape cylinder block of a combustion engine, in which said cylinder block comprises sleeves

liners CH and cooling units RE integrated when the core is drawn.

*Please amend the paragraph that begins on page 7, line 15 to read:*

FIG. 3a shows a cooling unit RE, as well as two cylinder sleeves-liners CH, in which the core N is drawn around the cooling unit and inside the sleevesliners.

*Please amend the paragraph that begins on page 7, line 18 to read:*

In this case, the cooling unit has a central hole T that enables a threaded rod or the like to pass through the aligned cooling units, in which said road-rod facilitates the tightening and rigidification of the central bundle of cores as well as its extraction after the casting.

*Please amend the paragraph that begins on page 8, line 22 to read:*

The mold comprises its die shoe SE, two cheeks C mobile in the directions indicated by the arrows-axis Fc in FIG. 5, vertically-mobile slide valves (not shown), a relay ladle LR connected to one of the cheeks C, a central bundle of cores PNC, risering cores M1, M2 and M3, and additional cores as necessary.

*Please amend the paragraph that begins on page 8, line 30 to read:*

FIG. 5 also shows shoulders B, which are made of metal, sleeves-liners CH in which the cylinder drums-barrels FC of the bundle of cores are formed, on which the shoulders B are glued or otherwise attached, and cores E for passages allowing water to circulate. The crankshaft bearing zones are designated by PV, while the reference AR designates the bearing surface between adjacent segments of the core, at the level of the cooling unit RE. This contact between the segments also occurs at the shoulders B.

*Please amend the paragraph that begins on page 9, line 7 to read:*

Finally, the central core consists entirely of the assembly of different core segments abutting one another at the bearing surfaces AR, and of the attachment, by adhesion, screwing or

~~the like, of the shoulders B on which the cores E for the passage of water will have previously been attached.~~

Finally, the central core on the whole consists in the assembly of the different core segments, abutting one another at the level of bearing surfaces AR, and in the attachment by adhesion, screwing or the like, of the shoulders B, on which the cores E, provided for the passage of water, will have previously been attached.

*Please amend the paragraph that begins on page 9, line 18 to read:*

The proper positioning of the core structure as described above shall now be described in reference to FIG. 6. This figure shows two lateral supports V and V' which first enable the ~~sleeves-liners~~ CH to be aligned with one another from one core segment to another, even though these segments have not yet been rigidly connected to one another. After this reference position is arranged, it is immobilized by any suitable means at the bearing surfaces AR of the different segments. The lateral supports V and V' are then retracted downwardly so as to release the segments. The assembly is completed as shown in FIG. 7, by positioning the shoulders B and attaching them to the ~~drums-barrels~~ FC, while the base of the bundle of cores is glued or attached to a reference bearing APP at the die shoe SE of the mold.

*Please amend the paragraph that begins on page 10, line 14 to read:*

The core has cast iron ~~sleeves-liners~~ machined on their internal and external surfaces. The entire mold is metal, and the ~~sleeves-liners~~ are supported by ~~drums-barrels~~ that are retractable through the die shoe.

*Please amend the paragraph that begins on page 12, line 4 to read:*

Moreover, the method according to the invention results in a standard deviation in terms of positioning of the ~~sleeves-liners~~ with respect to the reference frame of the block equal to 0.22 mm (mean standard deviation for all of the ~~drumsbarrels~~), substantially lower than the standard deviation of 0.25 mm obtained with the method of the prior art.